

# Work Order ID 52303

Tuesday, September 22, 2009 2:32:42 PM



Page 1

Item ID:	D2885	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Saddle Spacer					
Start Date:	9/23/2009	Start Qty:	40.00		Cust Item ID:	
Required Date:	10/9/2009	Req'd Qty:	40.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	09-9-22	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2885	Rev B								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2885 <input type="checkbox"/> Dwg Rev: <u>B</u> <input type="checkbox"/> Prog Rev: <u>B</u> <input type="checkbox"/> 2- Deburr if necessary								

Deburr m-h 09/10/19

72x

72

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

B 9-10-17

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

⇒ 808/10/19

72x

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*Tuesday, September 22, 2009 2:32:42 PM*

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**Setup Start**

**Stop**

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**Cust Item ID:**

**Customer:**

**Start Date:** 9/23/2009      **Start Qty:** 40.00

**Required Date:** 10/9/2009      **Req'd Qty:** 40.00

**Reference:**

Run Start



**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

**Stop**



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

Chemical Conversion Coat per QSI005 4.1

0.00



### HandFinish

## Memo

0.00

## Hand Finishing

140

QC5- Inspect part completeness to step on W/O

0.00



QC

## Memo

0.00

## Quality Control

150

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

**Abstract**

### Packaging

## Memo

0.00

## Packaging

**Work Order ID 52303**

Tuesday, September 22, 2009 2:32:42 PM



Page 3

Item ID: D2885

Accept



Setup Start



Revision ID: B

Stop



Item Name: Saddle Spacer

Start Date: 9/23/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/21 J

MF 09-10-21

# Picklist Print

Tuesday, September 22, 2009 2:32:41 PM

Page 1

Work Order ID: 52303



Parent Item: D2885RevB



Parent Item Name: Saddle Spacer

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			100	sf	110.7094	1.0821	2.000		



6061-T6 .080 Sheet

HB9-10-17

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

110.7094

107904

0.02

110254

2.5

110630

38.0926

112040

0.0437

112141

33

112512

37.0531

112.512

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 52303
<b>Description:</b> Saddle Spacer		<b>Part Number:</b> D2885
<b>Inspection Dwg:</b> D2885 <b>Rev:</b> B		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.43	+/-0.030	.432	✓			
0.443	+/-0.010	.440	✓			
Ø0.257	+0.006/-0.001	.260	✗			
R0.30	+/-0.030	.30	✗			
0.679	+/-0.010	.679	✓			
R0.40	+/-0.030	.40	✗			
0.250	+0.030/-0.000	.250	✗			
0.672	+/-0.010	.674	✗			
0.521	+/-0.010	.520	✗			
1.340	+/-0.010	1.345	✗			
2.681	+/-0.010	2.683	✗			
3.71	+/-0.030	3.701	✗			
R0.38	+/-0.030	.38	✗			
0.528	+/-0.010	.523	✗			
0.080°	+/-0.5°	.080°	✗			

<b>Measured by:</b> RB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 9-10-17	<b>Date:</b> 09/10/15	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue	KJ/JLM	

SHOP COPY

RETURN TO

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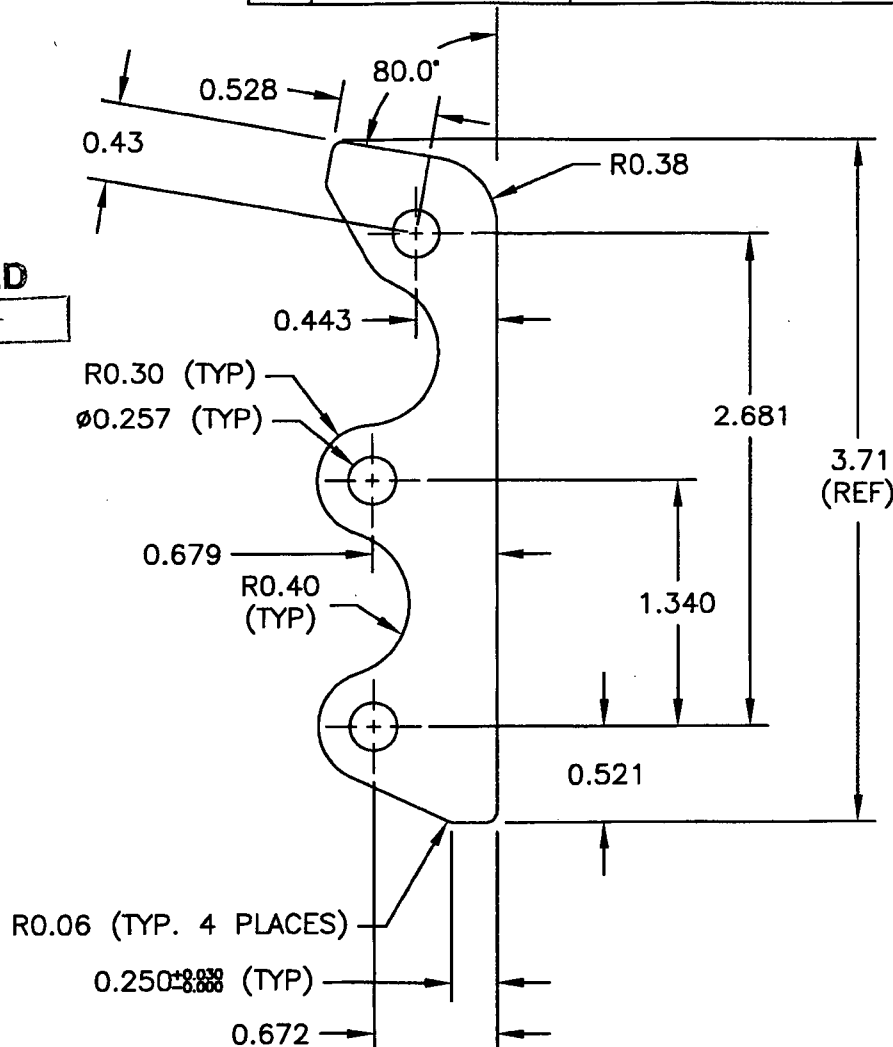
WORK ORDER

NO. 52303

**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2885	REV. B SHEET 1 OF 1
DATE 06.05.29	TITLE SADDLE SPACER		SCALE 1:1
A	99.04.01	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

**RELEASED**  
*06-06-20* *[Signature]*



**NOTES:**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR 5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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